

156054

Wednesday, January 25, 2017 12:37:52 PM

N900040100

Setup Start *NS1*

Stop ***NS2***

Cust Item ID:

Start Date: 1/25/2017 **Start Qty:** 12.00 ***12***

Required Date: 2/2/2017 **Req'd Qty:** 12.00 ***12***

Customer:

DAS
13
9-69

Approvals: _____ Process Plan: _____ Date: **JAN 25 2017**

Tooling: _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

156054

Wednesday, January 25, 2017 12:37:52 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 1/25/2017 **Start Qty:** 12.00 ***12***

Required Date: 2/2/2017 **Req'd Qty:** 12.00 ***1 2***

Customer:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

Work Order ID 156054

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156054

Page 3

Item ID: D2807-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Prop Assembly
Start Date: 1/25/2017 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 2/2/2017 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.20							
Quality Control									

17/2/23 JF
MF
17-2-22

Picklist Print

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Page 1

Work Order ID: 156054

156054

Parent Item: D2807-041

D2807-041

Parent Item Name: Prop Assembly

Start Date: 1/25/2017

Required Date: 2/2/2017

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: D 07.11.12 ecn1019, replaces D2807 ECverified by DD
IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
6/15-164/50-115N		Purchased		No		130	Each	0.0000	1	12			
6/15-164/50-115N								156054 (12) **				17/02/21	DAS 36 9-89
Gas Spring													
D3671-1		Manufactured		No		110	Each	10.0000	1	12			
D3671-1									**			17/02/21	DAS 36 9-89
Placard													

Location

Loc Qty

Loc Code

GA

10

150728

10

9/7/2017

10

B156055
(2)

SPECIFICATION CONTROL DRAWING

DAS
13
9-89

JAN 25 2007

W10: 156054

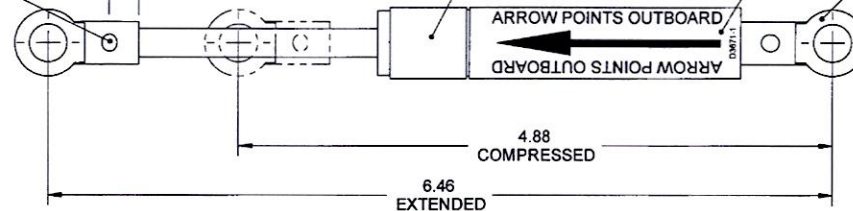
(ALTERNATE ONLY)
CRIMP 0.015-0.025 DEEP
WITH Ø0.375 TOOL AT
2000psi (REF), TYP TWO
SIDES PER LUG

0.24 TO CRIMP
(TYP)

D2807-5
OR
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD
ENSURE PLACARD DOES NOT
CONCEAL ANY TEXT OR MARKINGS
ON THE GAS SPRING

(ALTERNATE ONLY) D2807-3
BOTH ENDS



D2807-041 GAS SPRING

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

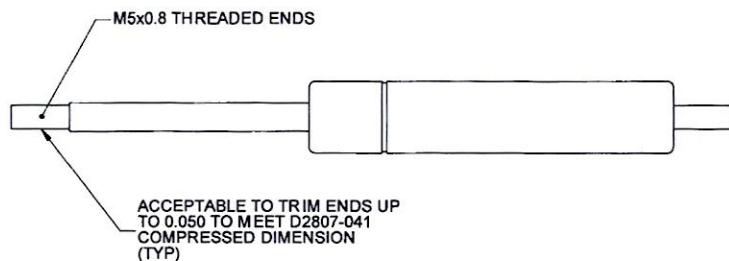
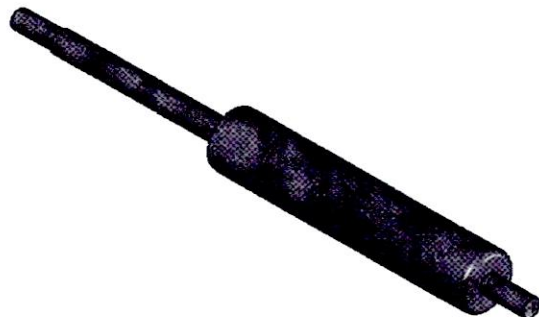
QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)
(WEIGHT: 0.176 LBS)

E

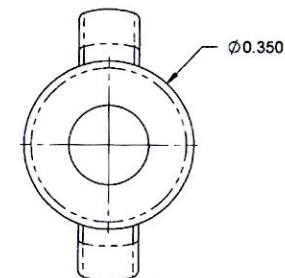
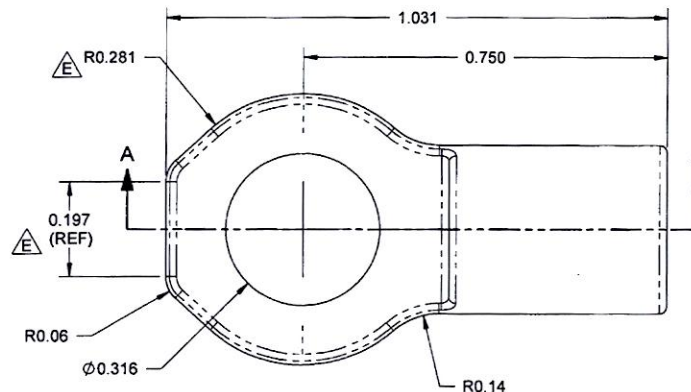
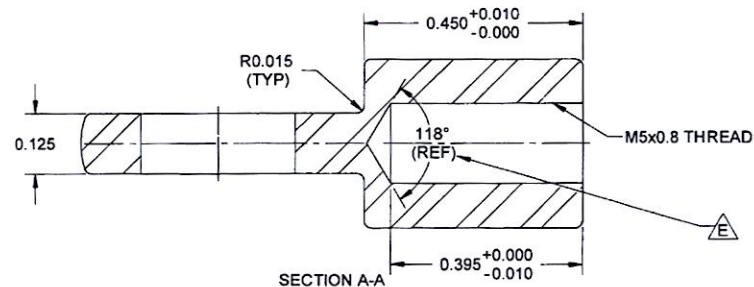
E	ADD D2807-5 GAS SPRING; D2807-1/-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AY		
CHECKED	JE	DRAWING NO.	REV. E
MFG. APPR.	JE	D2807	SHEET 1 OF 3
APPROVED	W.D.	TITLE	SCALE
DE APPR.	W.D.	GAS SPRING	NTS
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D2807-1 GAS SPRING
SCALE 1:1

D2807-1 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
(P/N SXF6S6050080S6L-115N)
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS

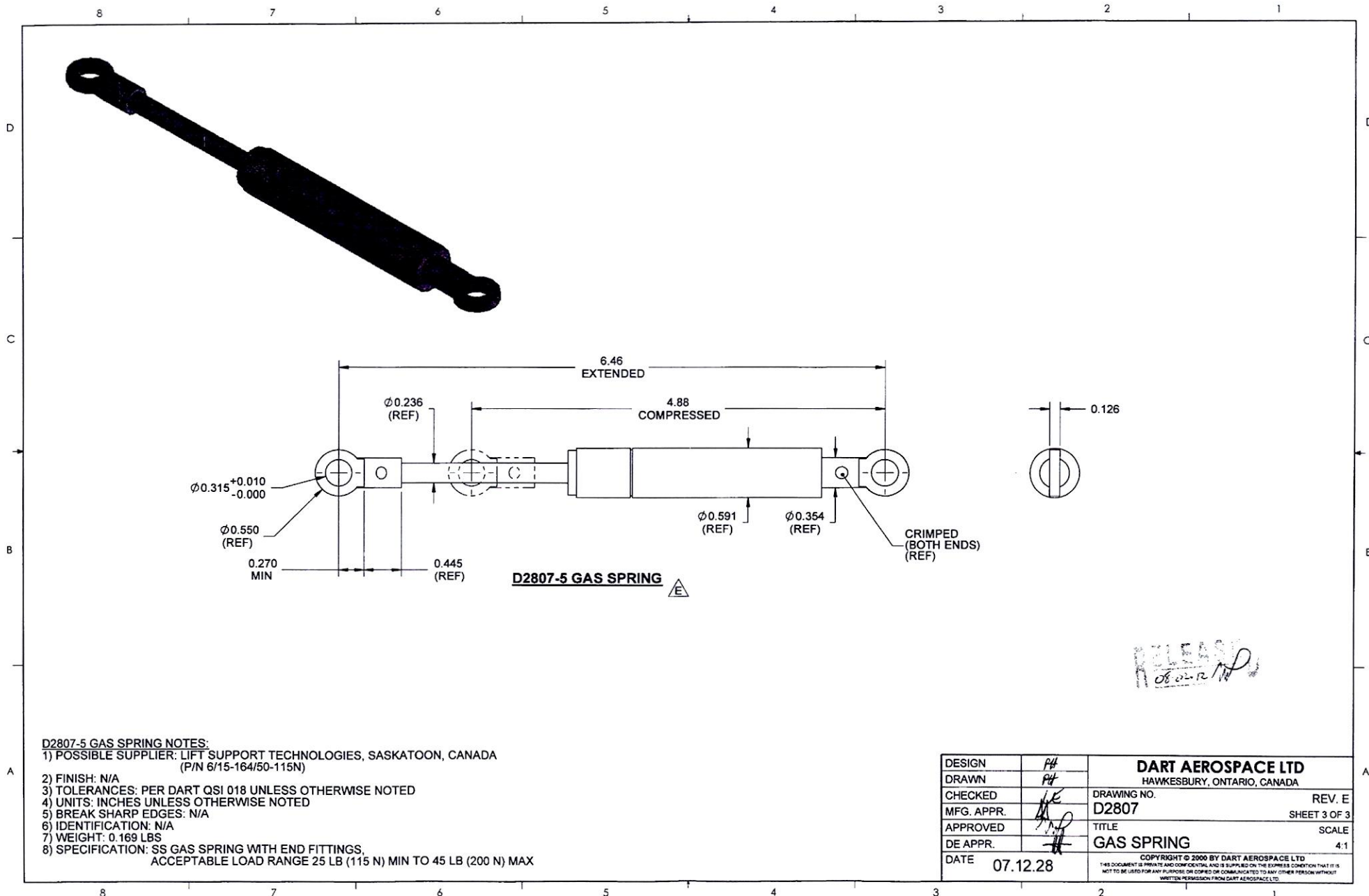


D2807-3 LUG

D2807-3 LUG NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS

DESIGN	H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	FE	DRAWING NO.	REV. E
MFG. APPR.		D2807	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GAS SPRING	4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35077**

Purchase Order Date 1/25/2017

PO Print Date 1/25/2017

Page Number 1 of 2

Order From :

LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

VC-LST0001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

JAN 25 2017

Contact Name
Vendor Phone 306 683 5000

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	SSA4/8-122-310-360N AS PER D3969 REV. D B155911	Gas Spring	1/31/2017 Yes 1/31/2017		10.00 Each	\$65.00	\$650.00
						Line Total:	\$650.00
2	B6-190-475-070N AS PER DWG D3552 REV. L B155820	Door Prop	1/31/2017 Yes 1/31/2017		8.00 Each	\$32.50	\$260.00
						Line Total:	\$260.00
4	6/15-164/50-115N AS PER DWG D2807 REV. E B156054	Gas Spring	1/31/2017 Yes 1/31/2017		12.00 Each	\$63.90	\$766.80

PO Instructions: Fedex Acc#151793240

Note:

1/25/2017



LS Technologies Inc
314 Jessop Ave
Saskatoon, SK, S7N 1Y6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Conformance

Jan 30, 2017

This is to certify that the parts listed below meets specifications as required by your order.

10 Units : D3969-3 B155911 Stainless Gas Spring

8 Units : D3552-23 B155820 Gas Spring

12 Units : D2807-041 B156054 Stainless Gas Spring

Country of Manufacture : Canada

Date of Manufacture : Jan 2017

This product is ROHS compliant.

Purchase Order # 35077

Inv# 16014

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read 'Nolan Fehr', written over a horizontal line.

Nolan Fehr
President

LS Technologies Inc
314 Jessop Ave
Saskatoon, SK S7N 1Y6

Ph: 306-683-5000 Fax: 306-683-6403

Packing Slip

P.O. No.	Date	Invoice #
35077	1/30/2017	16014

Bill to:

Dart Aerospace Ltd
1270 Aberdeen St.
Hawkesbury, ON K6A 1K7

Ship to:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St.
Hawkesbury, ON K6A 1K7

Ship	Via	FOB
1/30/2017	Fed-Ex	

Qty	Description
10	D3969-3 B155911 Stainless Gas Spring (SSA4/8-122-310-360N)
8	D3552-23 B155820 Gas Spring (B6-190-475-070N)
12	D2807-041 B156054 Stainless Gas Spring (6/15-164/50-115N)
Shipping Via FED EX Tracking # 778307449273	

FEB 01 2017

DAS
6
9-89

DAS
38
9-89

Order checked by :